10

PROVIDING A TEMPERATURE
CONTROLLABLE ENVIRONMENT AT
AN INITIAL TEMPERATURE
— 12

↓

PLACING THE ARTICLE IN THE
TEMPERATURE CONTROLLABLE
ENVIRONMENT
— 14

↓

HOLDING THE INITIAL
TEMPERATURE UNTIL
SUBSTANTIALLY ALL OF THE
SUPPORT STRUCTURE IS REMOVED
— 16

↓

LOWERING THE TEMPERATURE TO
JUST ABOVE THE FREEZING POINT
OF THE BUILD MATERIAL
— 18

↓

HOLDING THE TEMPERATURE
UNTIL THE TEMPERATURE OF THE
OBJECT SUBSTANTIALLY
EQUALIZES
— 20

↓

LOWERING THE TEMPERATURE
BELOW THE FREEZING POINT AT A
RATE WHEREIN A TEMPERATURE
DIFFERENTIAL WITHIN THE
OBJECT DOES NOT EXCEED ABOUT
5°C
— 22

FIG. 1